

Date: Monday, 11/19/2007 4:04:31 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASSY
Job Number : 35858	
Estimate Number : 10678	
P.O. Number :	Part Number : D3443043
This Issue : 11/19/2007 S.O. No. :	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 35140	Material :
Written By :	Due Date : 12/8/2007 Qty: 6 Um: Each
Checked & Approved By : <u>Kim Johnston</u>	
Comment : EST. REV. A 05.11.17 NEW ISSUE EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34437	Tubing
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Pick:

Qty	Part Number	Description
1	D3443-7	TUBING

Batch  
B34901

FC 08 01 21 (5)

2.0	D34433	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Pick:

Qty	Part Number	Description
1	D3443-3	CLEVIS

Batch  
B35160

FC 08 01 21 (5)

3.0	238805	SS DOWEL PIN 3/4" LONG
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Pick:

Qty	Part Number	Description
1	238-805	SS DOWEL PIN 3/4" LONG

Batch  
105037 FC 08 01 21 (5)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1  
Weld assembly as per dwg D3443

FC 08 01 21 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/19/2007 4:04:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 35858

Part Number: D3443043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-21 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/21 (45)

7.0

POWDER COATING

POWDER COATING



M106379



(5X)

Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-L 08/01/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/01/22 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57205

PC 8/01/22 (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.23

Job Completion



W 08.01.23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

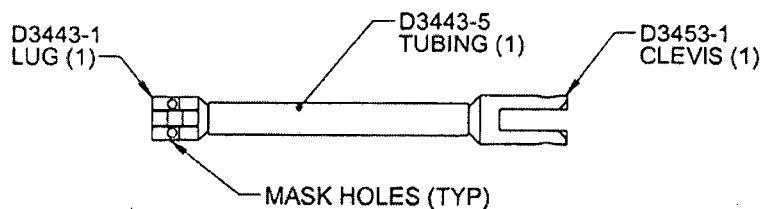
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

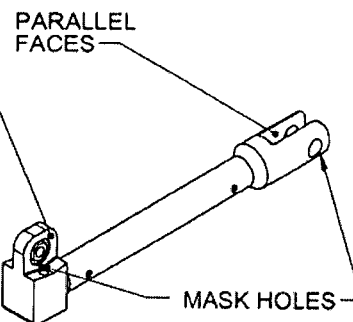
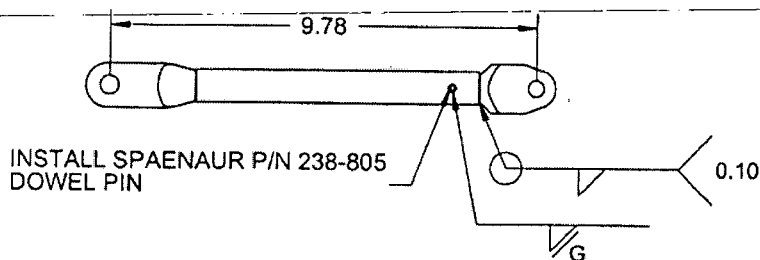
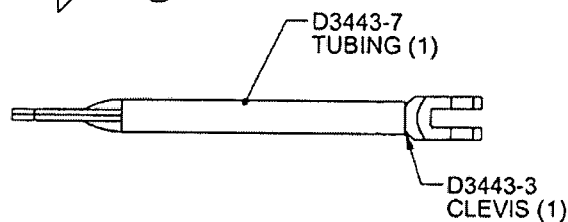
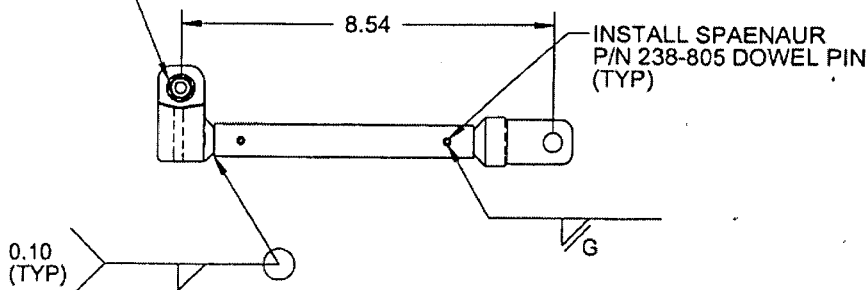
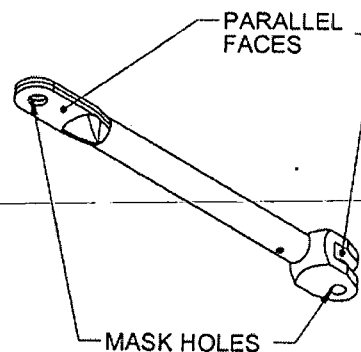
**NOTE:** Date & initial all entries

**DART**

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DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-043**

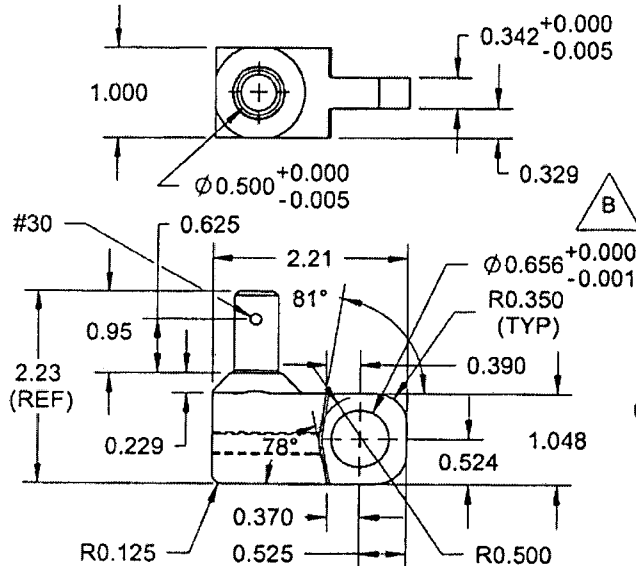
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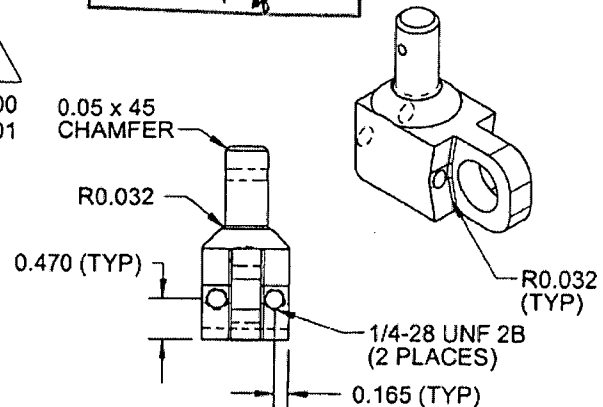


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DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:2	



**RELEASED**

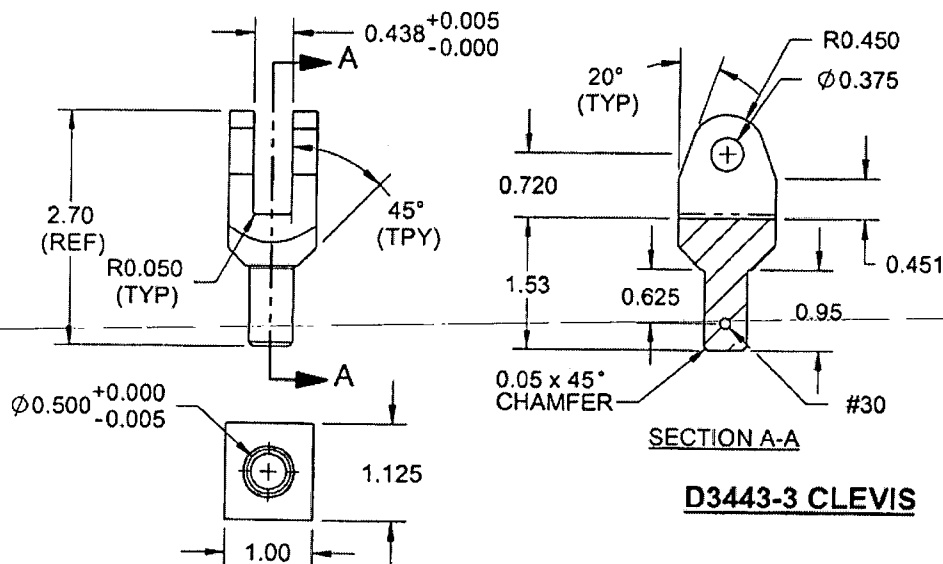
05.12.04 *[Signature]*



**D3443-1 LUG**

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



**D3443-3 CLEVIS**

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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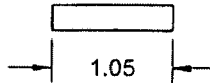
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DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY 1:2</b>		

$\varnothing 0.210^{+0.005}_{-0.010}$



### D3443-9 PIN

#### D3443-9 NOTES:

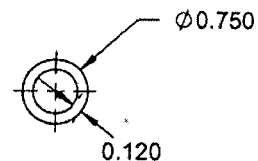
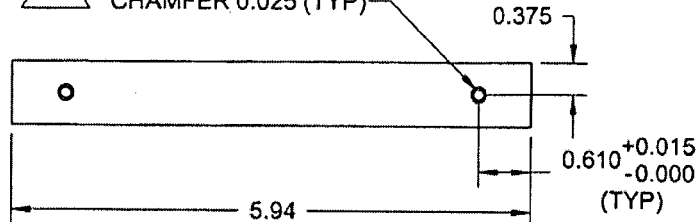
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09 *[Signature]*

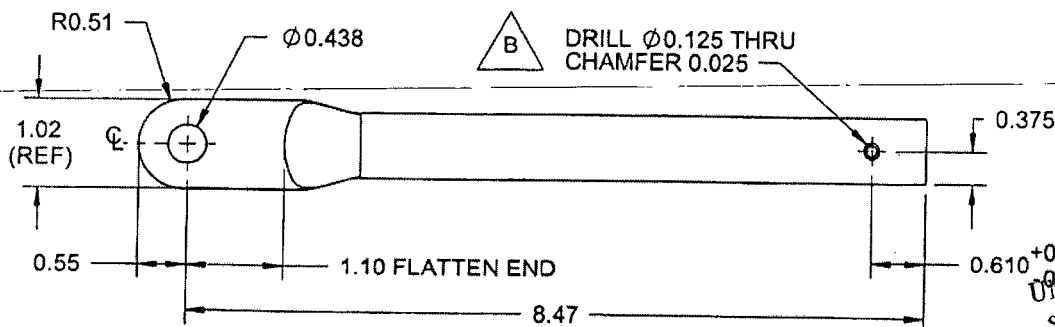
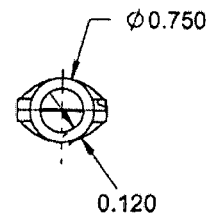
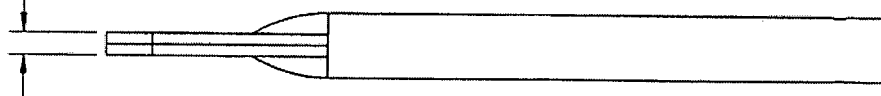


DRILL  $\varnothing 0.125$  THRU  
CHAMFER 0.025 (TYP)



### D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL  $\varnothing 0.125$  THRU  
CHAMFER 0.025

### D3443-7 TUBING

#### D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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